

Date: Monday, 06/10/2008 1:20:24 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ACCESS PANEL ASSEMBLY		
Job Number	: 42466			Part Number	: D3245043		
Estimate Number	: 13010			Drawing Number	: D3245 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/10/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 20/10/2008 Qty: 4 Um: Each		
Previous Run	: 40184						
Written By	:						
Checked & Approved By	: <u>JUL 08 10.06</u>						
Comment	: Est Rev:A New Issue 07-09-11 JLM Verified By:EC Est Rev:b ECN 1052 07-10-31 DD verified by:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D32453	Door	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
	Door		
	Batch: <u>D412487</u>		
3.0	D32457	Gasket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
	Gasket		
	Batch: <u>B35668</u>		
4.0	235120009C3Y	STUD	
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)		
	STUD		
	Batch: <u>M106484</u>		
5.0	127H35	HALF GROMMET	
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)		
	HALF GROMMET		
	Batch: <u>M18245</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 1:20:24 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 42466

Part Number: D3245043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Studs and Gromets as per Dwg D3245

3-Bond Gasket using 3M ADHESIVE as per Dwg D3245

A/R 3M 1300/1300L ADHESIVE Batch: 1109410

08/10/29 (4)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/29 (4)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



(4)

Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock

Location: 182

8/10/29

8/29

9.0 QC21 FINAL INSPECTION/W/O RELEASE



08/10/30 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

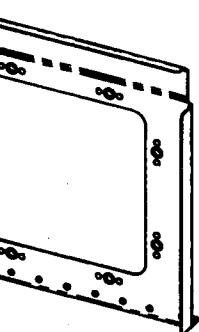
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

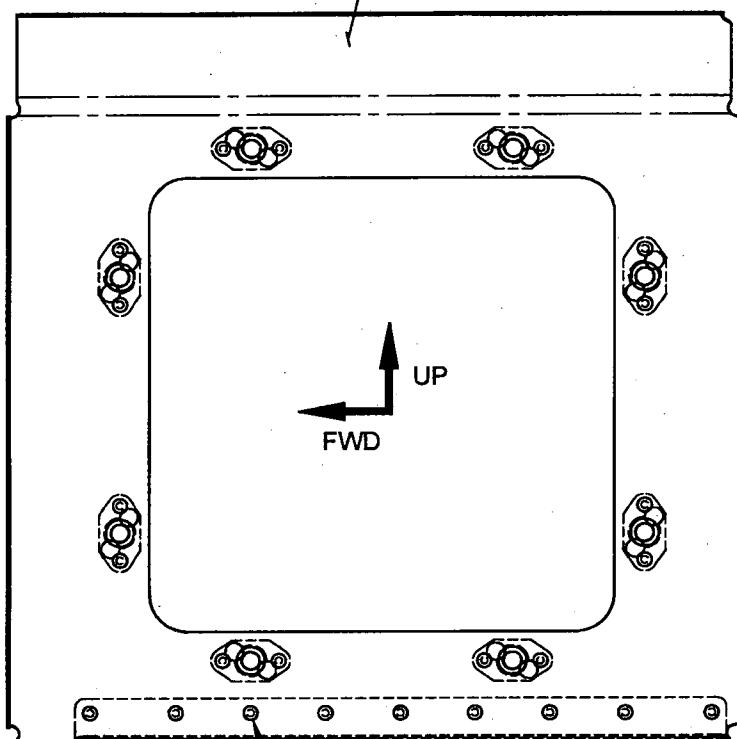
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D

D3245-1
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

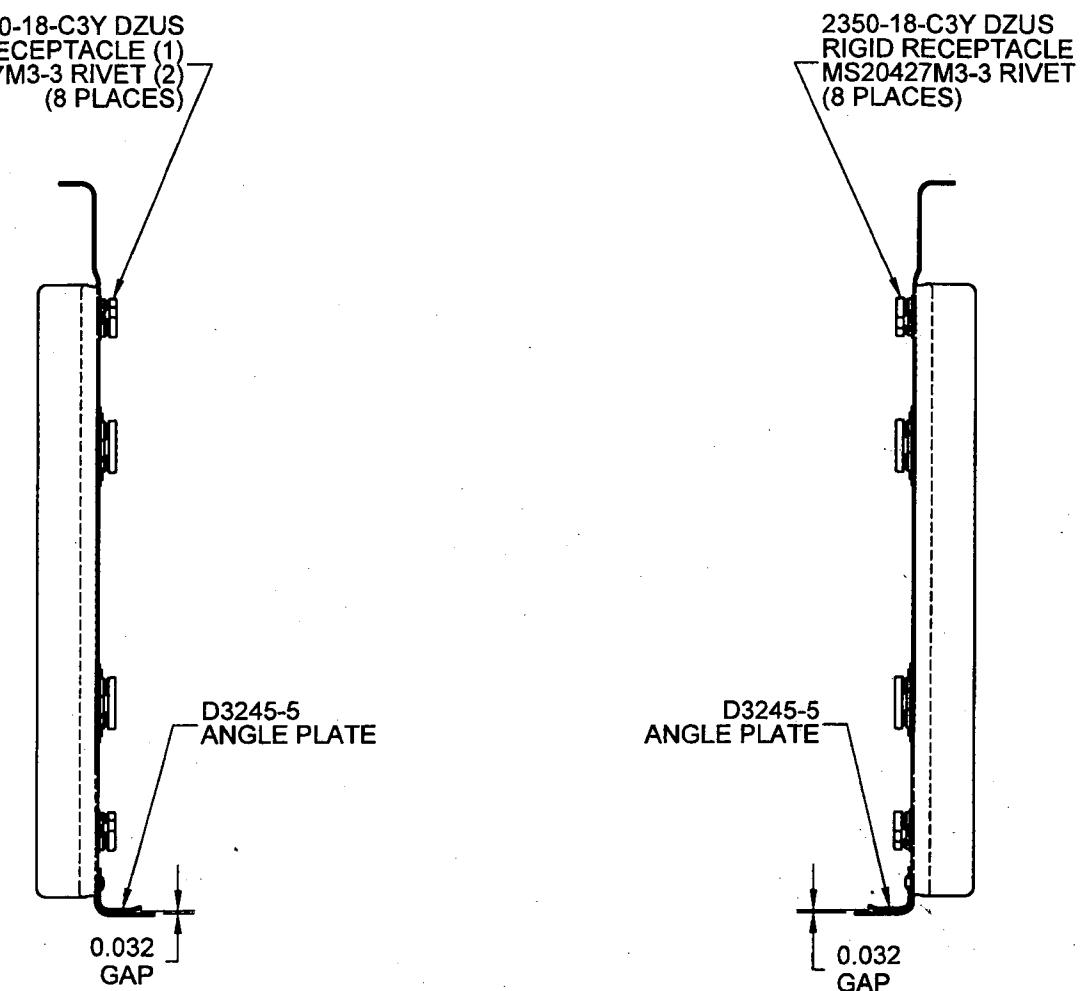


MS20615M3-3 RIVET
(9 PLACES)

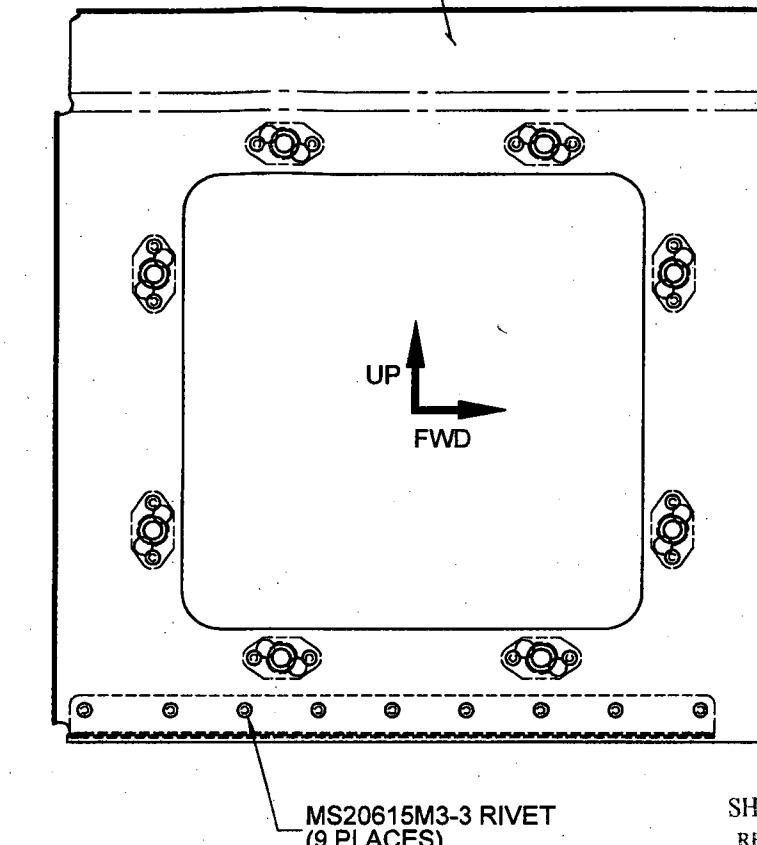
D3245-041 ACCESS PANEL ASSEMBLY

RELEASED
11/07/02

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.83 lbs

D3245-2
PANEL

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



MS20615M3-3 RIVET
(9 PLACES)

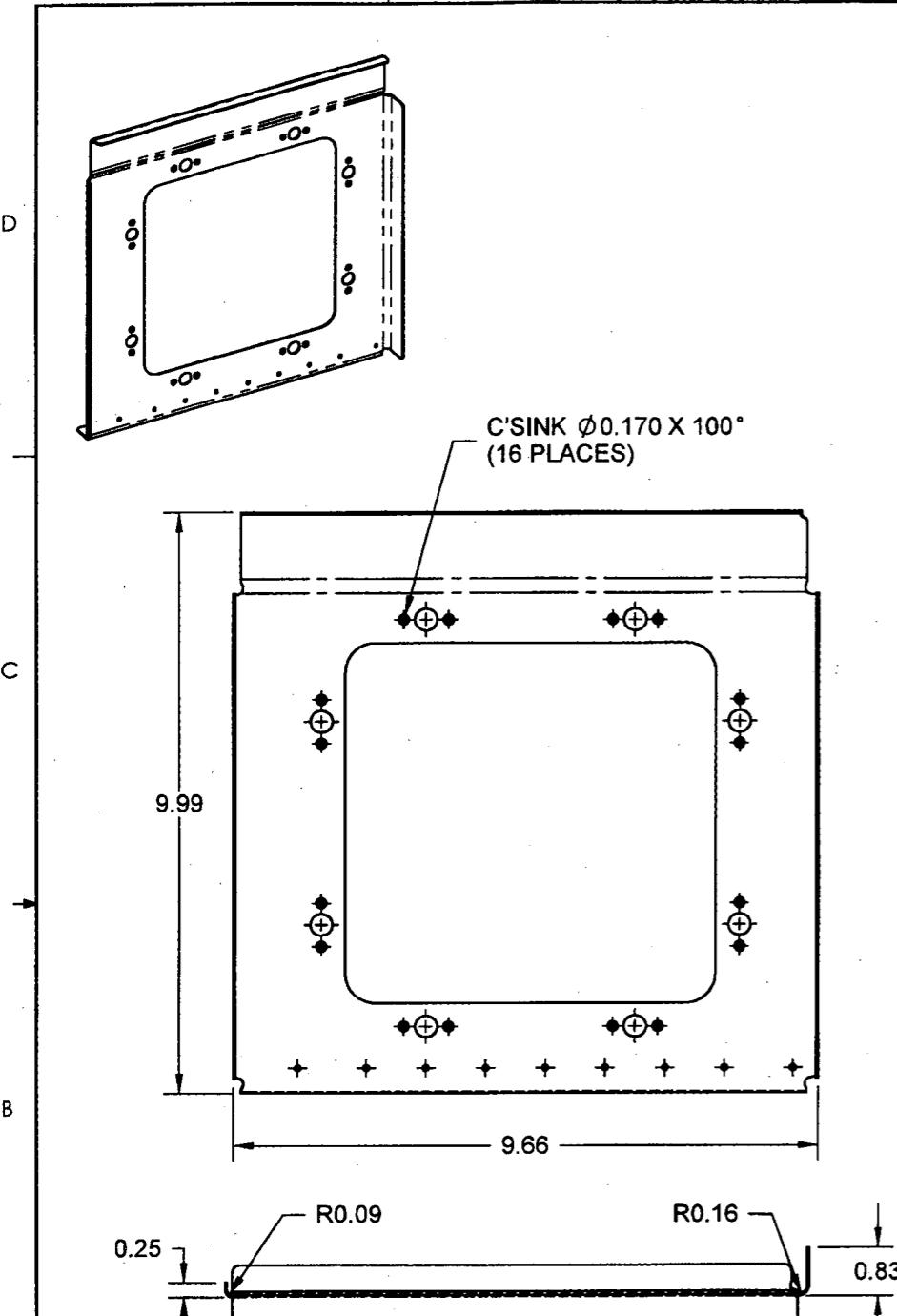
D3245-042 ACCESS PANEL ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

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WORK ORDER
11/07/02

NO. _____
MB 07.10.02
RF 04.01.27
BY DATE

B	REMOVE Ø0.204 HOLES FROM D3245-1-1F, REMOVE MS21060-L3K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/042; HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	NO. _____ MB 07.10.02 RF 04.01.27 BY DATE
A	NEW ISSUE	
REV.	DESCRIPTION	
DESIGN	1F	DART AEROSPACE LTD
DRAWN	1B	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. _____
MFG. APPR.	DD	REV. B
APPROVED	10	D3245
DE APPR.	SH	SHEET 1 OF 7
DATE	07.10.02	SCALE 1:2.5
		ACCESS PANEL ASSEMBLY
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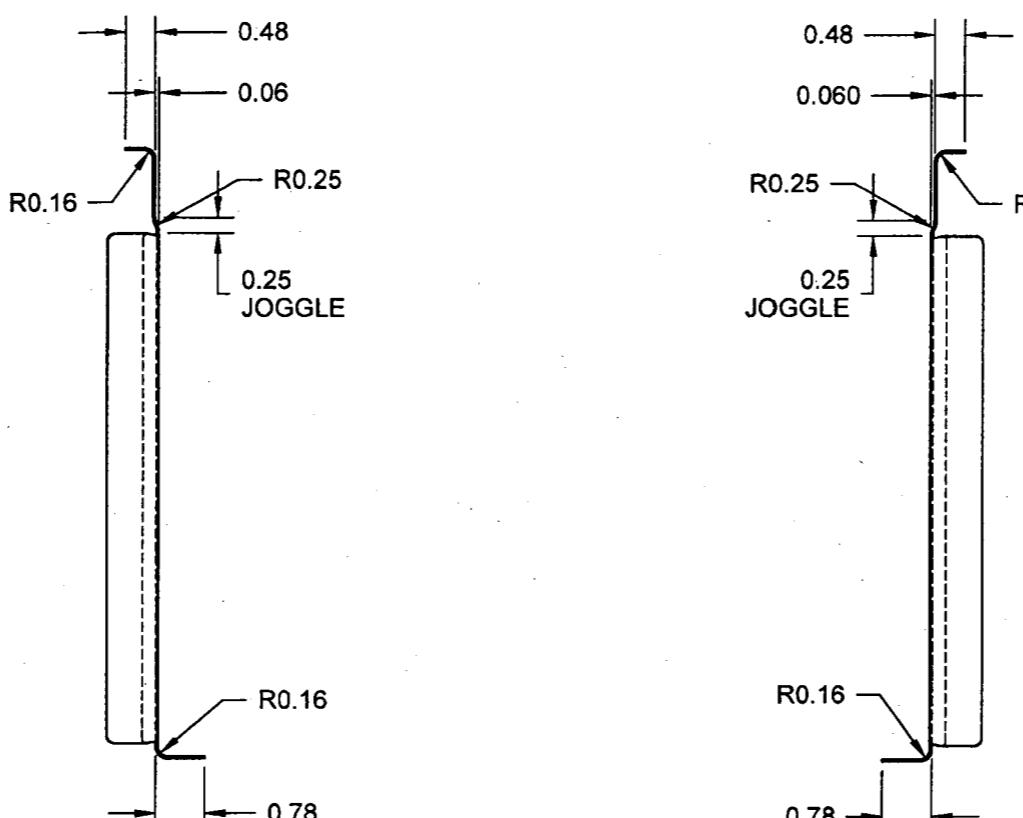
D3245-1 PANEL BEND DETAIL, LH

RELEASED
10/07/10 23

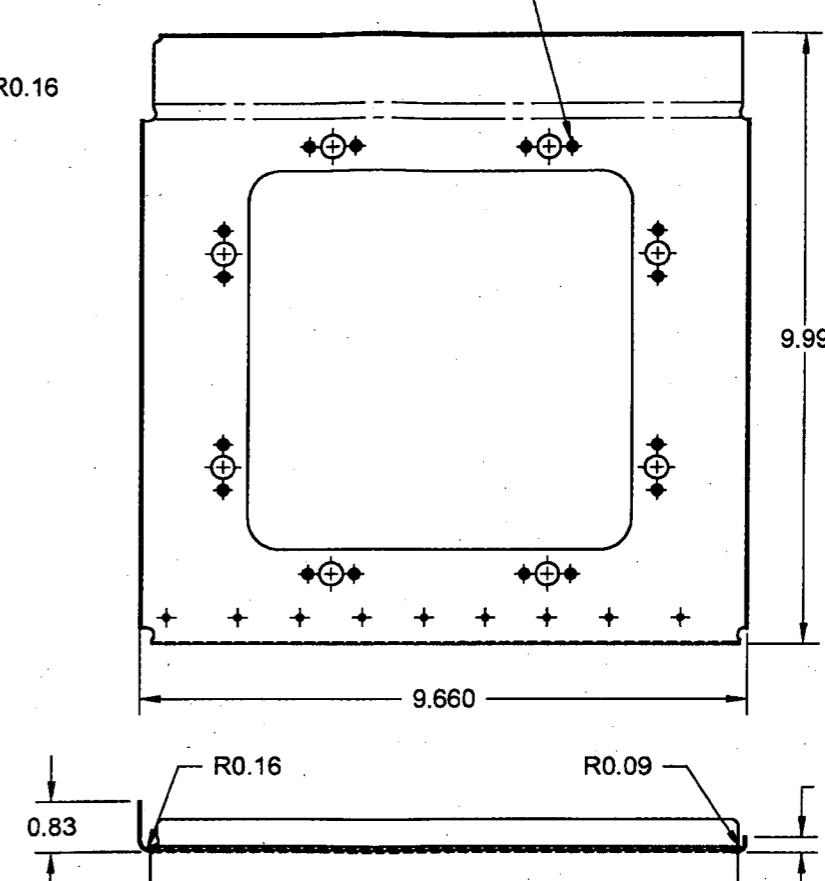
NOTES:

NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs



A technical drawing of a C-Sink component. The component is L-shaped with a rectangular cutout on the inner vertical leg. The outer vertical leg has a height of 100° and a top width of 0.170. The inner vertical leg has a height of 0.170 and a top width of 100°. There are two rows of holes: an inner row with 6 holes and an outer row with 8 holes. The overall width of the component is 100°.



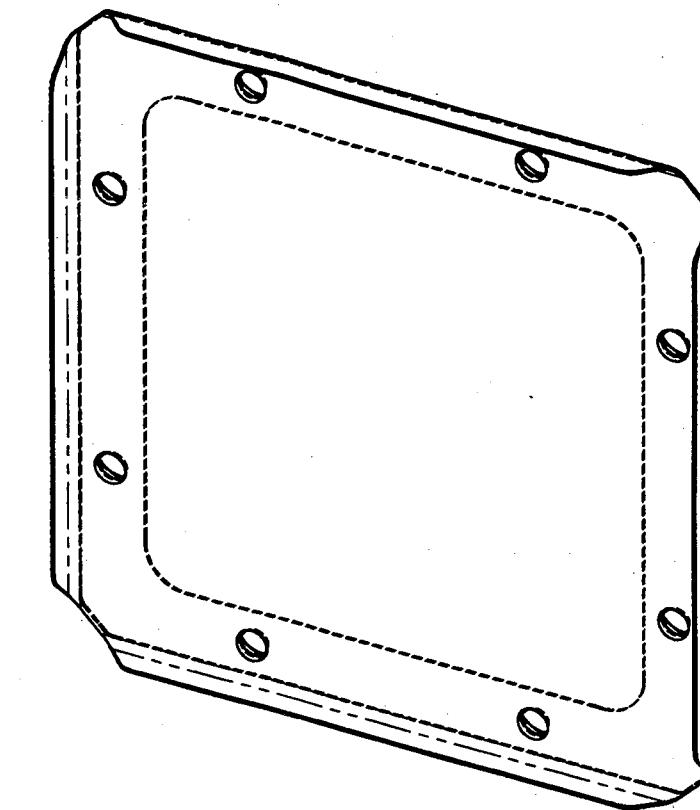
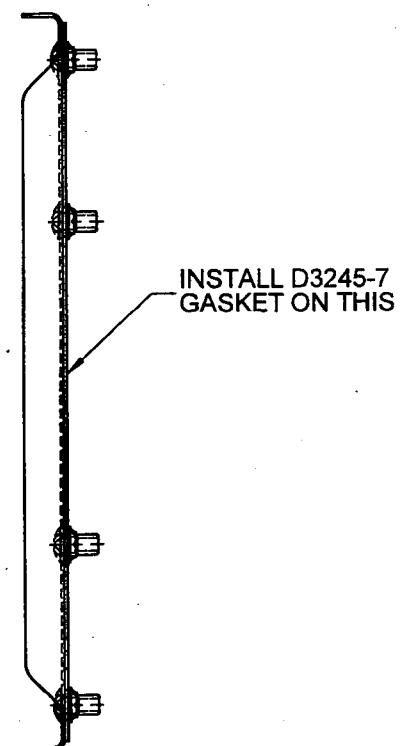
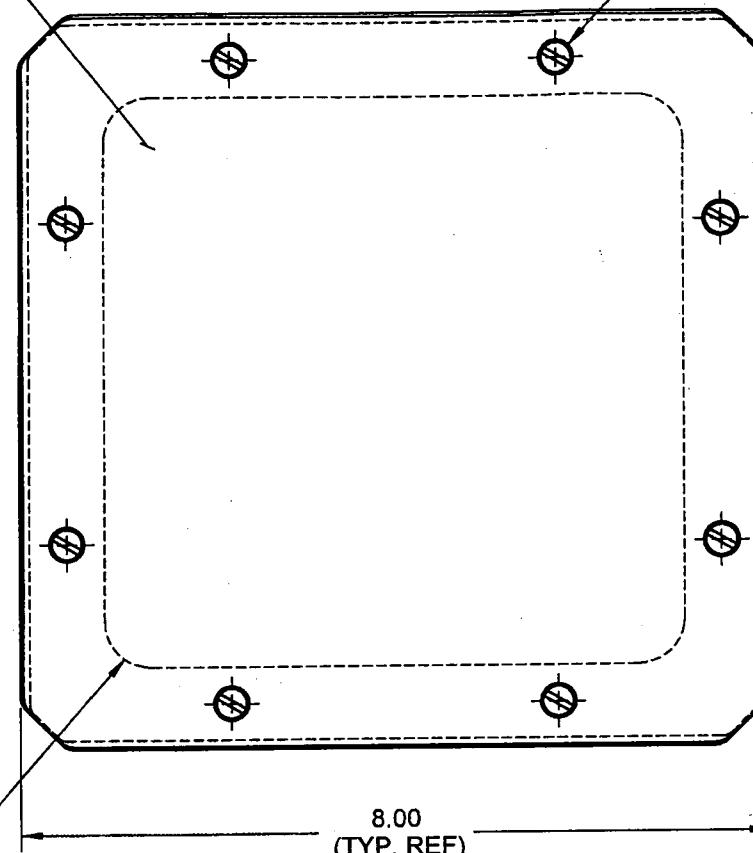
D3245-2 PANEL BEND DETAIL, RH

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DESIGN	PF	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	MO	TITLE ACCESS PANEL ASSEMBLY	
DE APPR.	SH		
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D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)



D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

RELEASED
10/07/02

NOTES:

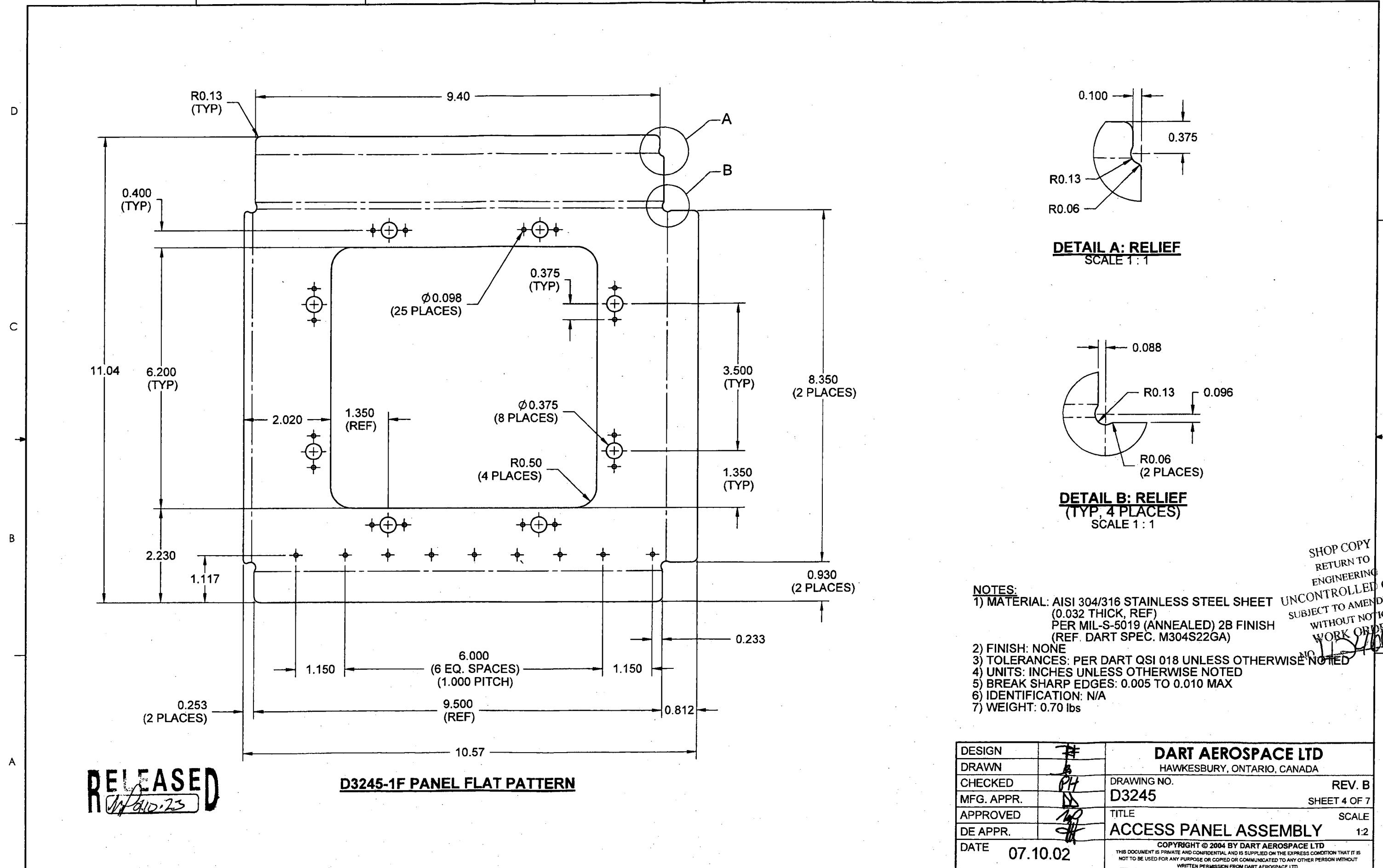
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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CHECKED	PH	DRAWING NO.	
MFG. APPR.	XX	D3245	REV. B
APPROVED	NO	SHEET 3 OF 7	
DE APPR.	XX	SCALE	
DATE	07.10.02	1:2	

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8 7 6 5 4 3 2 1



DESIGN	7	DART AEROSPACE LTD
DRAWN	8	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	ND	REV. B
APPROVED	ND	SHEET 4 OF 7
DE APPR.	ND	TITLE
DATE	07.10.02	SCALE
		ACCESS PANEL ASSEMBLY

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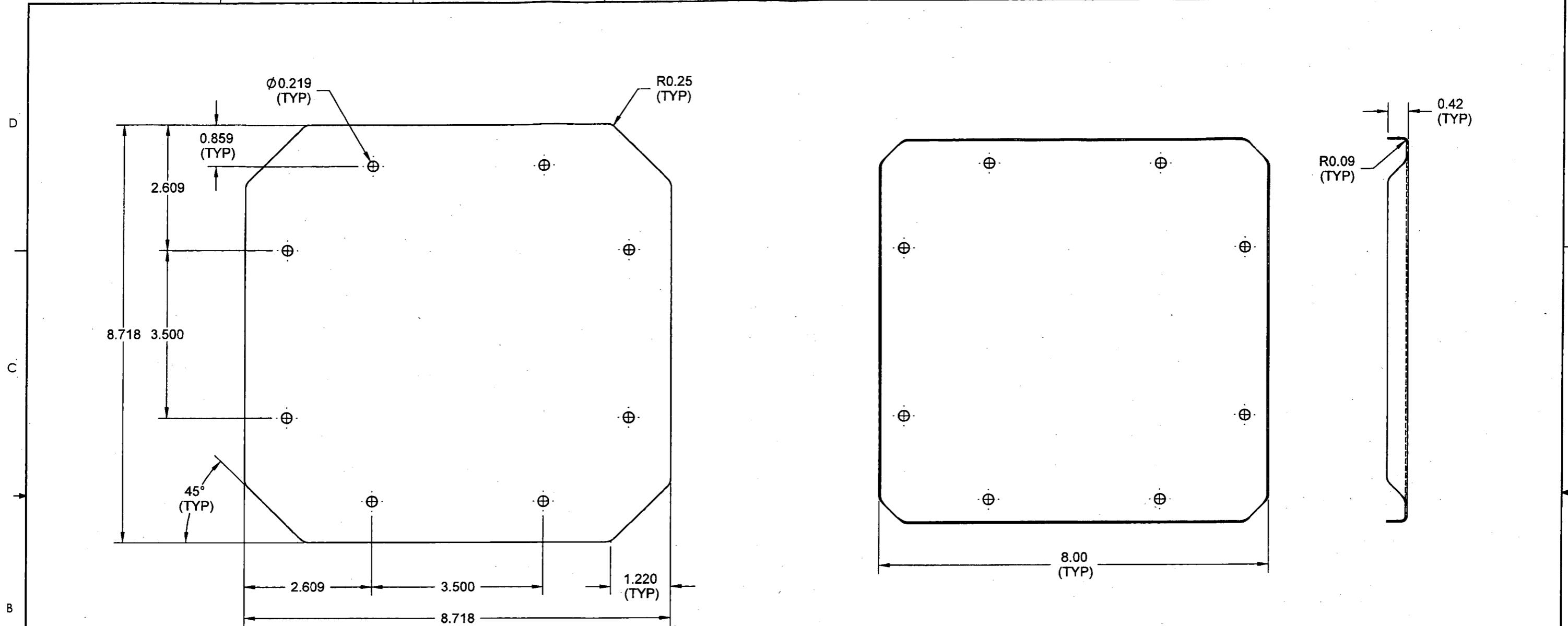
D

B

C

1

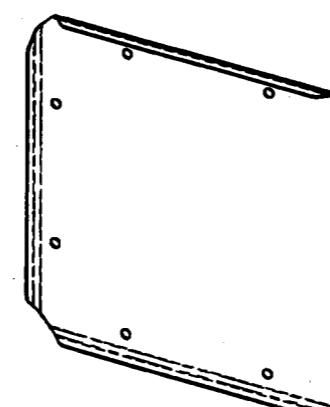
8 7 6 5 4 3 2 1



D3245-3F DOOR FLAT PATTERN

RELEASED
07.10.02

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
 PER MIL-S-5019 (ANNEALED) 2B FINISH
 (REF. DART SPEC. M304S22GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.67 lbs



D3245-3 DOOR BENDING DETAIL

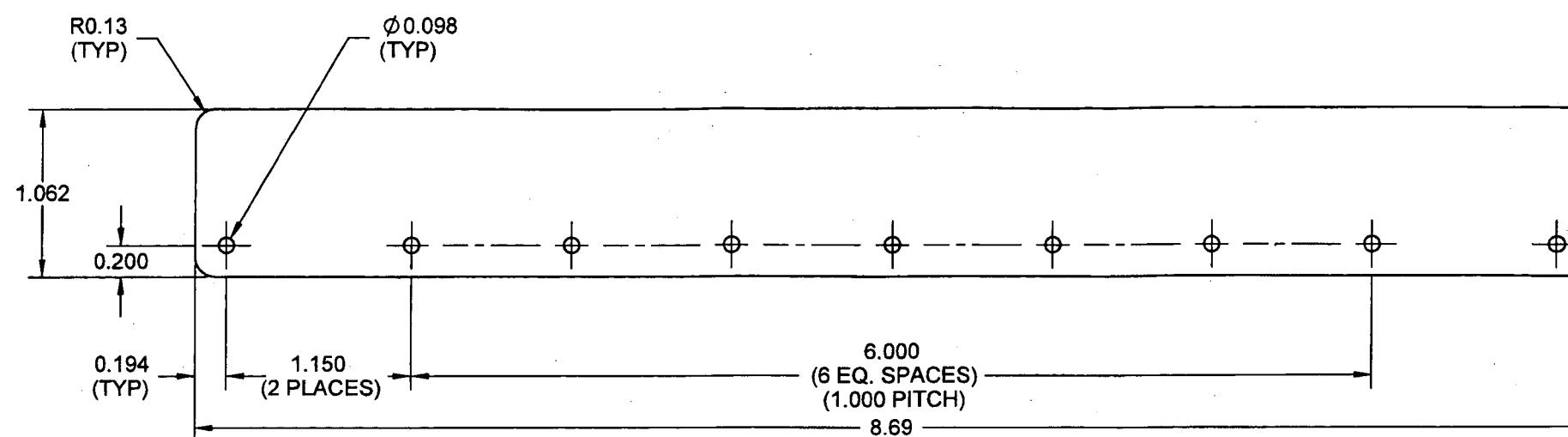
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DESIGN	RF	DART AEROSPACE LTD
DRAWN	b	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245
MFG. APPR.	DS	REV. B
APPROVED	100	SHEET 5 OF 7
DE APPR.	100	TITLE
DATE	07.10.02	SCALE
		ACCESS PANEL ASSEMBLY
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8 7 6 5 4 3 2 1

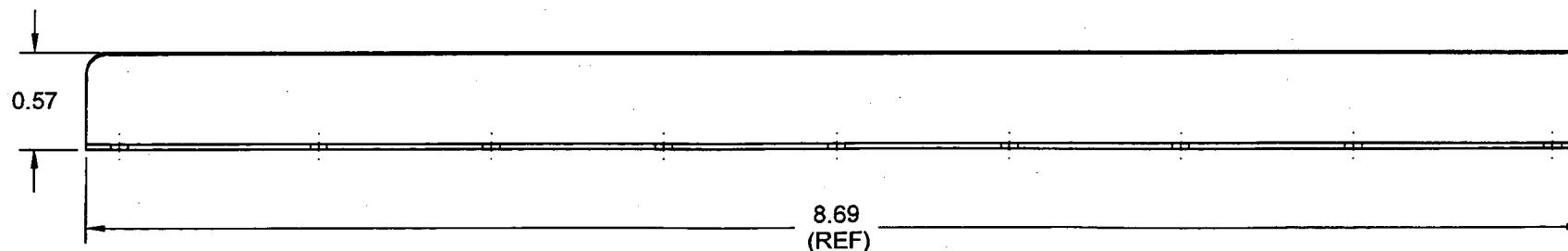
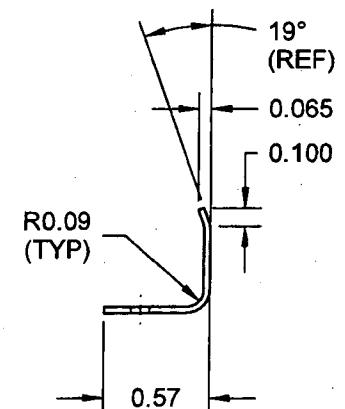
D

D

**D3245-5F FLAT PATTERN**

C

C

**D3245-5 BEND DETAIL**
(MAKE FROM D3245-5F)

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NO. *1224*

RELEASED
07.10.02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>PF</i>	DART AEROSPACE LTD
DRAWN	<i>B</i>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. D3245
MFG. APPR.	<i>DA</i>	REV. B
APPROVED	<i>MO</i>	SHEET 6 OF 7
DE APPR.	<i>MM</i>	TITLE ACCESS PANEL ASSEMBLY
DATE	07.10.02	SCALE 1:1

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8

7

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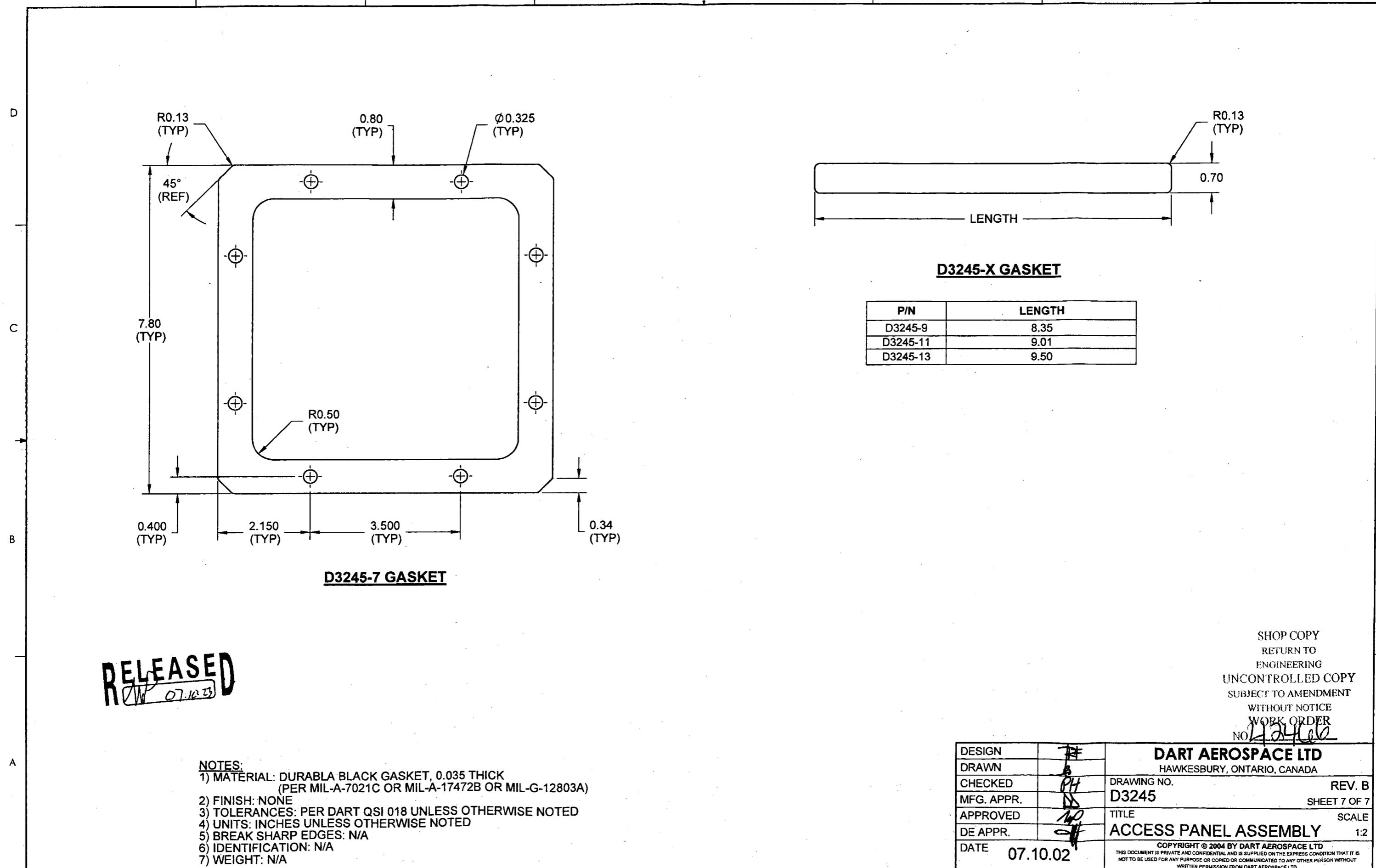
4

3

2

1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1